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D2150

Job Sheet 181204



Part No: D2150

Job Qty: 20 ea

Part Name: Packer Doubler, Hinge



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP C 00.11.27 Re-format (mpp 2101) EC IPP Rev:D 06-08-23 Now on Waterjet JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		8/31/18	0.00	0.00	Start Up Waterjet		SC 8/18/19
100	Waterjet	20 pcs		8/31/18	0.00	0.60	Waterjet1		SC 8/18/19
110	QC	20 pcs		8/31/18	0.00	0.00	QC2 Waterjet-1		SC 8/18/19
120	QC	20 pcs		8/31/18	0.00	0.00	QC8-1		18-08-10 38
130	Small Fab	20 pcs		8/31/18	0.00	0.43	Small Fab-1		N/A 9-89
140	HandFinish	20 pcs		8/31/18	0.00	0.31	HandFinish1		DR 18-08-15
150	Powdercoat	20 pcs		8/31/18	0.00	0.14	Powdercoat1		W 18-08-15
160	QC	20 pcs		8/31/18	0.00	0.00	QC3		AUG 15 2018
170	Packaging	20 pcs		8/31/18	0.00	0.00	Packaging3-1		AUG 16 2018
180	QC21-SA	20 Ea		8/31/18	0.00	0.00	QC21		AUG 16 2018

Part Op 100 - 1-Cut as per Dwg D2150
Descriptions: 130 - Deburr
150 - START TIME 10:15am FINISH TIME: 10:42am 3265

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	.5000 sf (.025 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	1	90	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Packer	0.740Inches ± 0.010	0.750 0.730	0,744	
2	Packer	2.050Inches ± 0.010	2.060 2.040	2,056	
3	Packer	0.231Inches ± 0.010	0.241 0.221	0,234	
4	Packer	1.217Inches ± 0.010	1.227 1.207	1,220	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																										
Date : _____	Step #: _____	(QSI042) Approval Completed By _____ and / Supervisor _____ QA Coordinator _____ Approval _____																																										
Description Work Order Devia																																												
Part: D2150 Job No: 181204 Serial No/Batch: S100799 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 08/09/18 Container No: S100799																																												
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width:33%;">Environment ☐</td> <td style="width:33%;">No Re-verification ☐</td> <td style="width:33%;">Pressure/Fr ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/bulge/wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> </tr> </tbody> </table>						Root Cause			Environment ☐	No Re-verification ☐	Pressure/Fr ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/bulge/wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐	
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5	Packer	1.559Inches ± 0.010	1.569 1.549	1,560
6	Packer	2.300Inches ± 0.010	2.310 2.290	2,303
7	Packer	1.560Inches ± 0.010	1.570 1.550	1,566
8	Packer	0.250Inches ± 0.010	0.260 0.240	0,254
9	Packer	1.328Inches ± 0.010	1.338 1.318	1,330
10	Packer	0.342Inches ± 0.010	0.352 0.332	0,345
11	Packer	0.098Inches + 0.005 - 0.000	0.103 0.098	0,100 Diameter
12	Packer	0.171Inches + 0.005 - 0.000	0.176 0.171	0,174 Diameter
13	Packer	0.040Inches ± 0.010	0.050 0.030	0,040

Plex 7/24/18 9:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					